

Work Order ID 62233

Wednesday, September 22, 2010 3:31:12 PM

Page 1

Item ID: D3535-25

Accept

Revision ID:

Item Name: Wearshoe

Start Date: 9/22/2010 Start Qty: 10.00

Required Date: 9/29/2010 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

Date: 10-9-23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3535

Rev B

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535

☐ Dwg Rev:

B

☐ Prog Rev:

B

☐ 2-

Debur if necessary

B10-9-30

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B10-9-30

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

S1010101

714

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

Wednesday, September 22, 2010 3:32:24 PM

Page 1

Work Order ID: 62233



Parent Item: D3535-25



Parent Item Name: Wearshoe


Start Date: 9/22/2010

Required Date: 9/29/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA  304/316 .040 Sheet		Purchased	No			100	sf	33.3987	0.51	5.368421	7.2	10-9-30	

Location

Loc Qty

Loc Code

MAT 10.6522
114574 10.6522
MAT20 22.7465
112885 2.7475
113062 0.699
115440 19.3
115762

115762

(14)

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DART AEROSPACE LTD		Work Order:	42233
Description: Wearshoe		Part Number:	D3535-25
Inspection Dwg: D3535 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.891	✓		V B02	
1.937	+/-0.010	1.937	✓		V	
1.450	+/-0.010	1.450	✓		V	
5.450	+/-0.010	5.450	✓		V	
10.900	+/-0.010	10.900	✓		T B01	
16.350	+/-0.010	16.350	✓		T	
21.800	+/-0.010	21.800	✓		T	
Ø0.188	+0.005/-0.001	.190	✓		V	
12.750	+/-0.010	12.750	✓		T	
6.75	+/-0.030	6.748	✓		V HB02	
6.00	+/-0.030	6.000	✓		V	
0.300	+/-0.010	.301	✓		V	
0.300	+/-0.010	.302	✓		V	
0.038	+/-0.010	.038	✓		V	

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	10-9-30	Date:	10/10/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	

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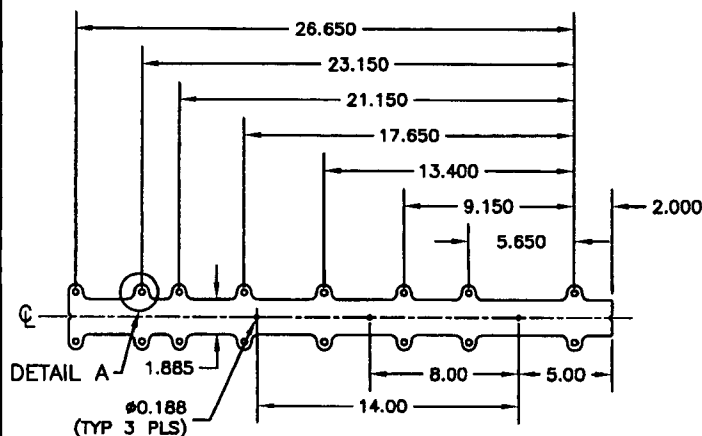
NOTE: Date & initial all entries

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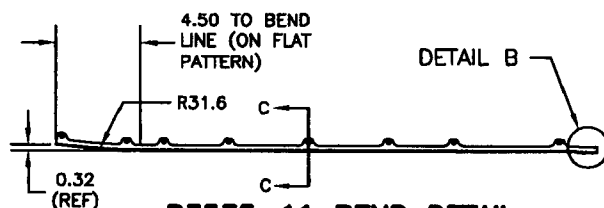
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07.04.17

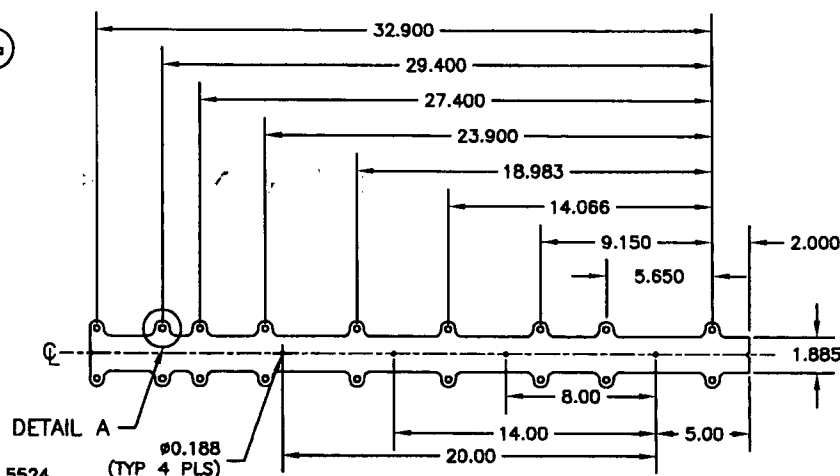
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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 62233
Bj 10-9-23



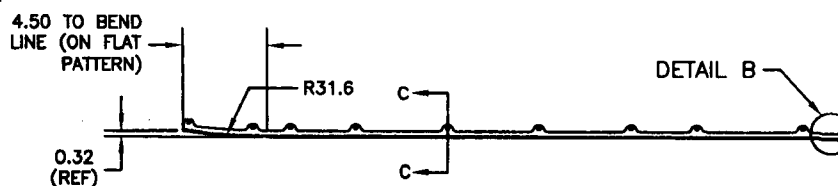
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	TITLE	REV. B
CB	PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D3535	SHEET 1 OF 7
DATE 07.04.17		WEARSHOE	SCALE 1:10
A	06.10.25	NEW ISSUE	
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	

W/O:		WORK ORDER CHANGES					
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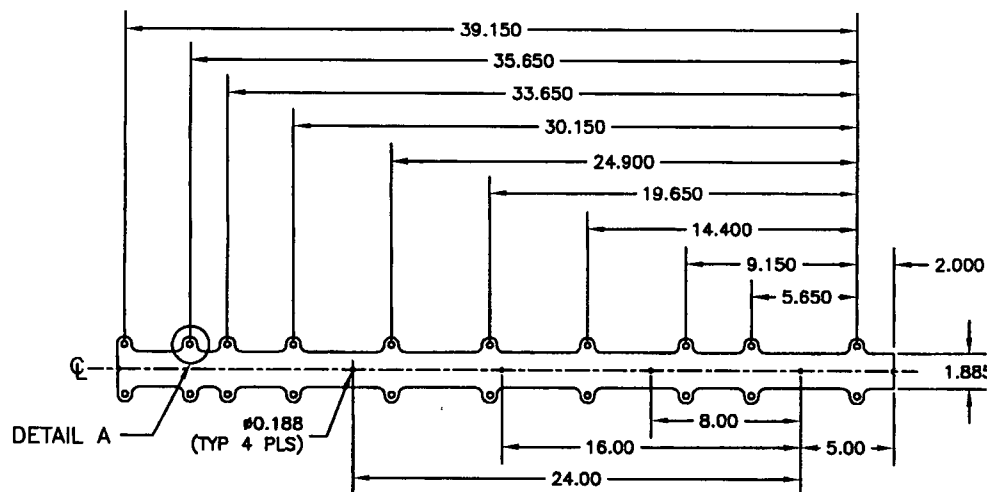
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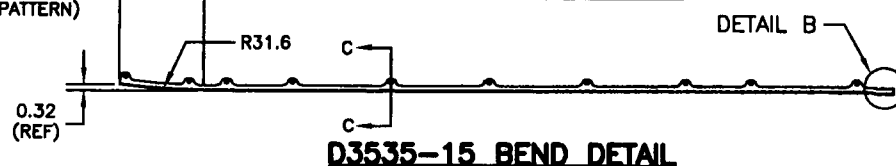
07.04.24

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		D3535	SHEET 2 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	



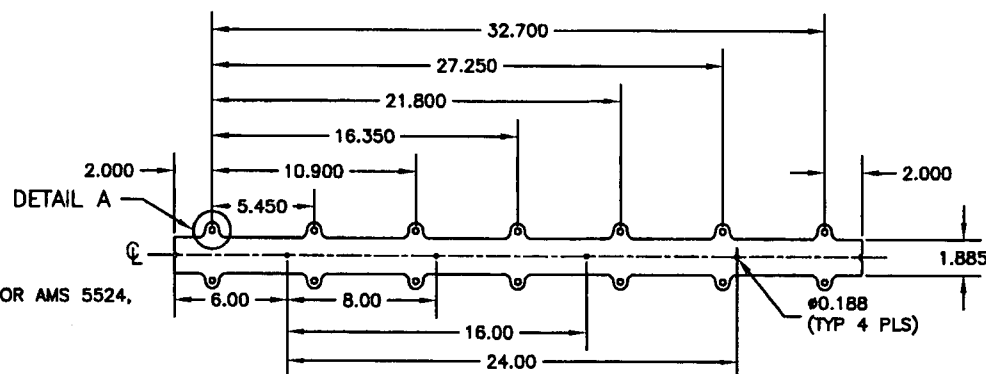
4.50 TO BEND
LINE (ON FLAT
PATTERN)

D3535-15F FLAT PATTERN

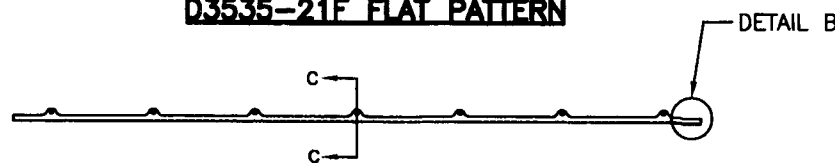


D3535-15 BEND DETAIL

W/G 62233



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

NOTES

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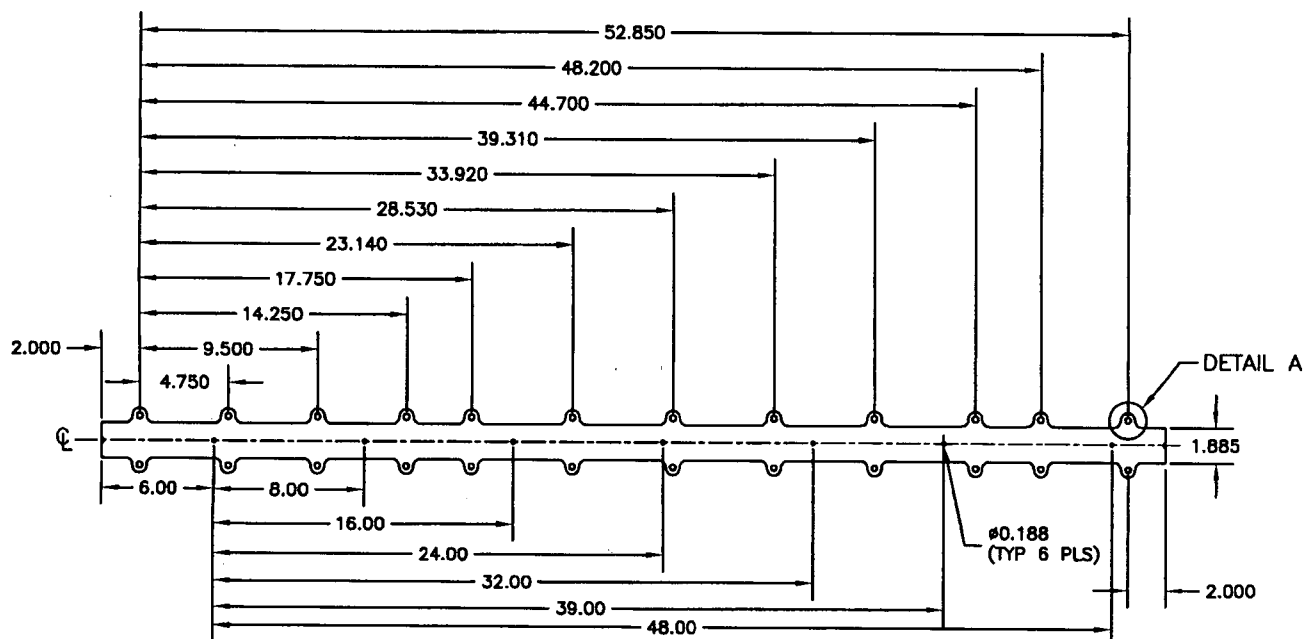
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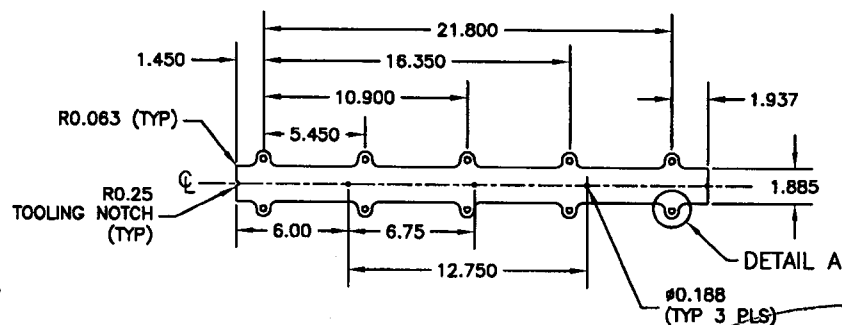
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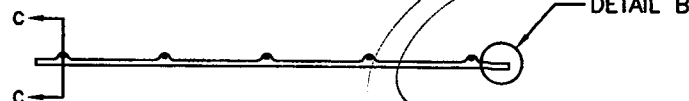
D3535-23F FLAT PATTERN



D3535-23 BEND DETAIL



D3535-25F FLAT PATTERN



D3535-25 BEND DETAIL

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07.04.17	WEARSHOE	SCALE 1:10
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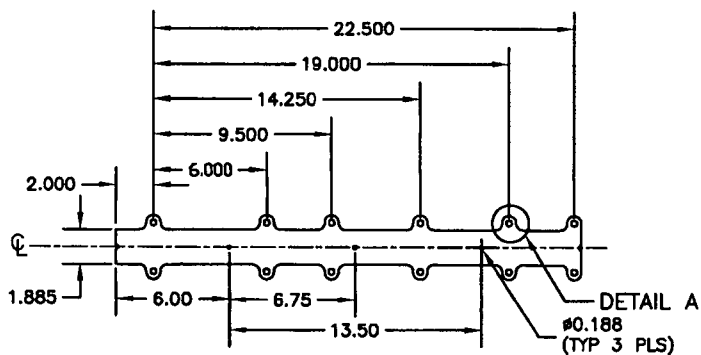
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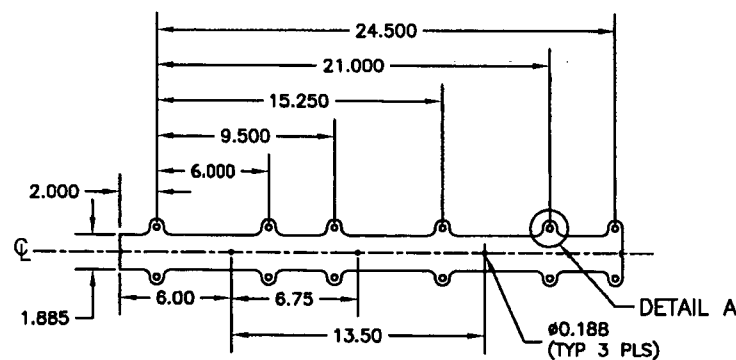


D3535-31F FLAT PATTERN



D3535-31 BEND DETAIL

W/O 42233



D3535-33F FLAT PATTERN



D3535-33 BEND DETAIL

NOTES

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		D3535	SHEET 4 OF 7
DATE	TITLE	SCALE	
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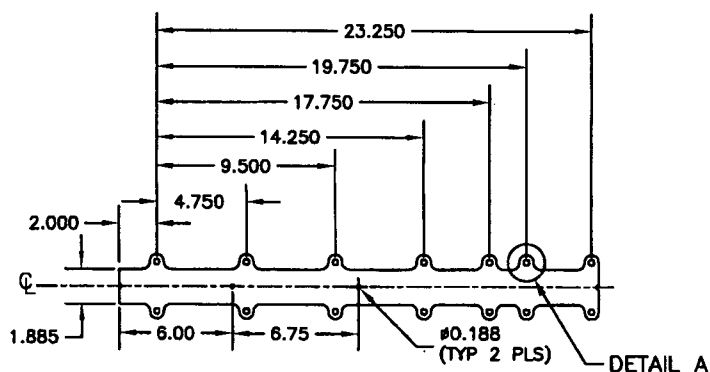
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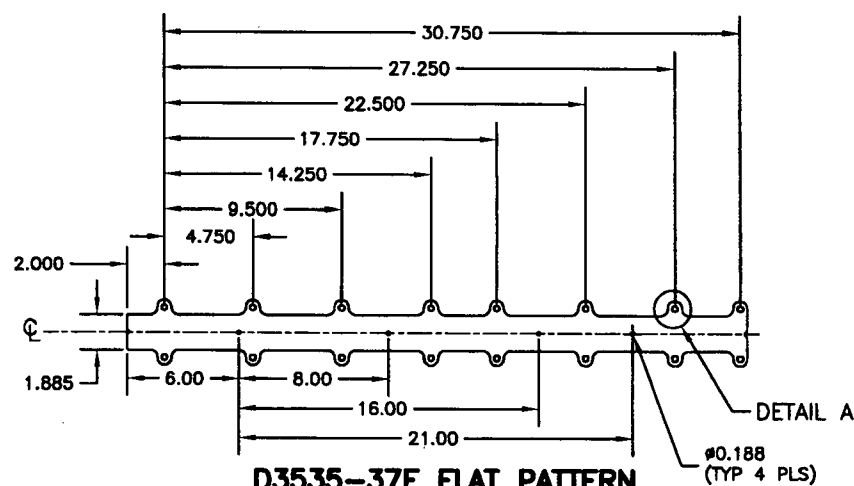
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CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
<i>[Signature]</i>	<i>[Signature]</i>	D3535	SHEET 5 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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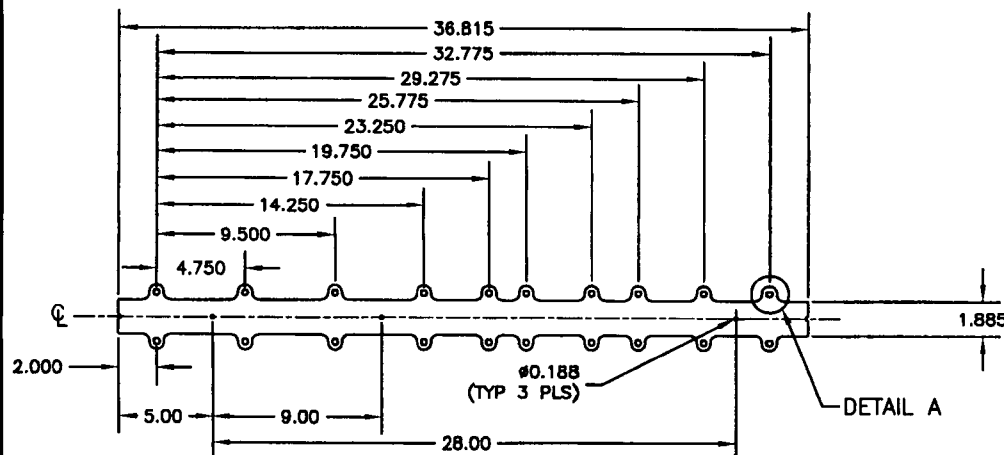
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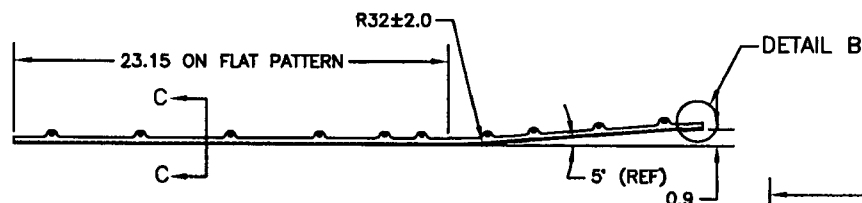
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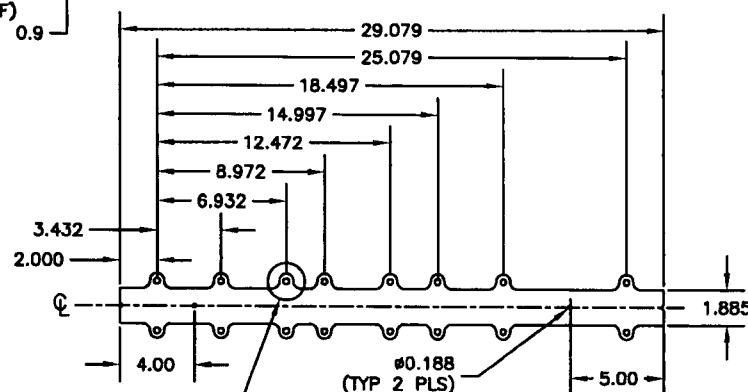
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	SHEET 6 OF 7
	SCALE 1:10	REV. B



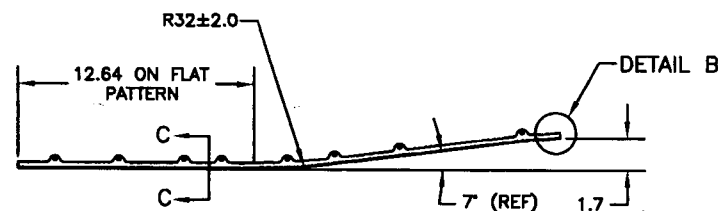
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

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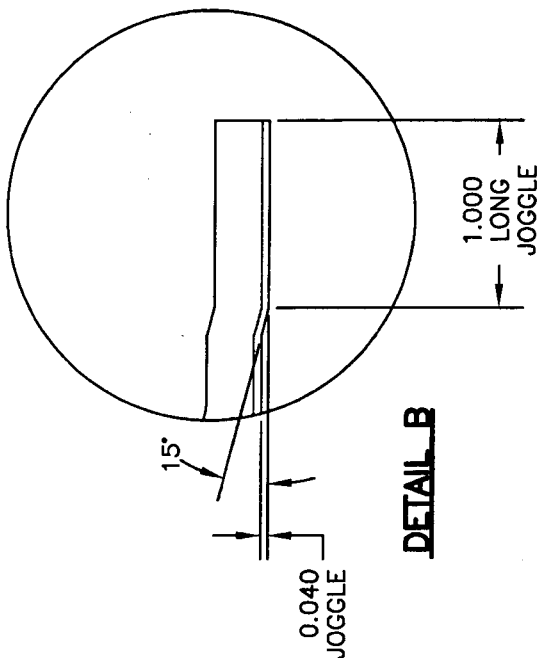
NOTE: Date & initial all entries



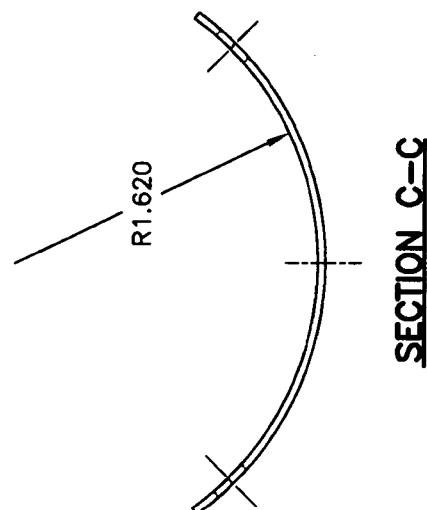
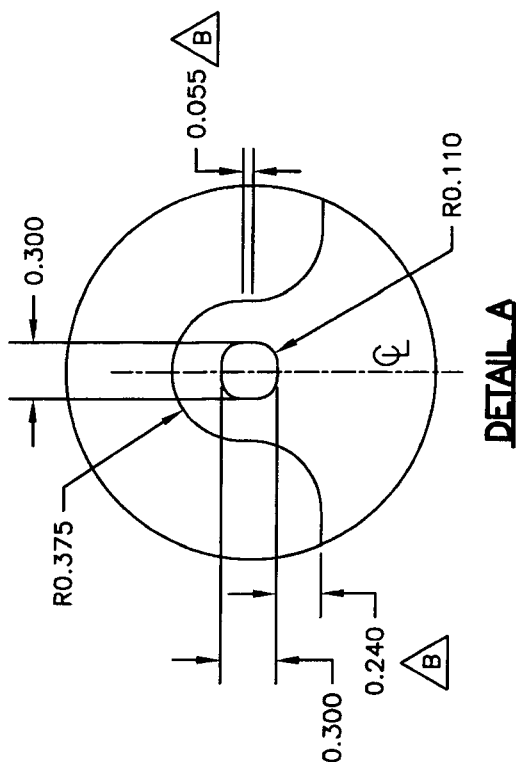
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

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07.04.24 *[Signature]*



w/o 42233



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